



Dart Hawkesbury
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Hawkesbury, ON
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Tel (613) 632-5200

D205-634-041
Job Sheet 165469



Part No: D205-634-041

Job Qty: 1 ea

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: California Department Of Forestry & Fire Protection (CCAL/01)

5500 Price Avenue McClellan, CA, 95652 USA ph:(916) 561-3359

Note: DWG REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D205-634-041 Replacement Skidtube with Standard Wearplates Fits LH or RH	DWG REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC		0.000	
ALS7-1032-130 Rivnut			0.000	
AN3-5A Bolt			0.000	
AN3C4A Bolt			0.000	
D2576-3 Step (Machining Detail)	DWG REV G IPP: E 02.08.19 Consolidated D2576-1 and D2576-3 KJ/RF IPP Rev:D As per Rev G 07-09-05 JLM Verified By:EC		0.000	
D2580-1 205 Bent Tube	DWG REV G SHEETS 1,2,3,8 IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM IPP Rev:C 10.12.01 as per DEO D1 DD verf:ec		0.000	
D2594-1 Plug	DWG REV C IPP D 02.08.22 Make in Cobra KJ IPP E 06.12.11 ecn 836 EC		0.000	
D2594-3 O-Ring	DWG REV C IPP B 04.06.08 Reformat; Added Powder Coat KJ/JLM IPP C 06.12.11 ecn 836 EC		0.000	
D2855 Cap	DWG REV C IPP: B 00.06.22 Added receiving step & removed P/O for powder coat EC		0.000	
D3564-11 Wearplate Aft	DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:		0.000	
D3564-13 Wearpad Fwd	DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev:D Comments revised on Step 5, 6 per B44657 09-02-04 KJ Verified By:EC		0.000	
D3564-5 Wearplate Center	DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev D added DT# 08.04.21 DD Verified by EC		0.000	
D3564-9 Wearplate Fwd	DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC		0.000	
D3566-1 Gasket Aft / Fwd	DWG REV C IPP Rev:A New Issue 07-03-08 ec IPP Rev:B Added Drain Holes 07-07-09 JLM IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC		0.000	
D3566-13 Gasket Fwd	DWG REV C IPP Rev:A New Issue 07-03-08 ec IPP Rev:B Added Drain Holes 07-07-09 JLM IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC		0.000	
D3566-5 Gasket Center Aft	DWG REV C IPP Rev:A New Issue 07-03-08 ec IPP Rev:B Added Drain Holes 07-07-09 JLM IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC		0.000	

DART
AEROSPACE
S003063

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Hawkesbury, ON K64 1K7
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www.dartaerospace.com



Replacement Skidtube with Standard Wearplates Fits LH or
RH

PART NO:
Revision:
Operation:
Quantity:
Change No:

D205-634-041

Start up Operation

1

Mfg Date: 10/27/17
Job No: 165469

D4202-1

Spacer

DWG REV C IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP REV:B

0.000

AS PER REV B 11-04-05 JLM VERIFIED BY:DD IPP Rev:C 11.12.19 PER

DWG REV.C DD verf:EC

NAS1149C0332R

Washer

0.000

NAS1149D0332J

Washer

0.000

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/30/17	0.00	0.00	Start up container	
100	DC	1 pcs	10/30/17	0.00	0.00	DC	
110	CNC Bend Skidtubes	1 pcs	10/30/17	0.00	0.65	CNC Bend Skidtube	
120	Skidtubes	1 pcs	10/30/17	0.00	0.00	Skidtubes	
130	QC	1 pcs	10/30/17	0.00	0.00	QC5	
140	Skidtubes	1 pcs	10/30/17	0.00	0.00	Skidtubes	
150	QC	1 pcs	10/30/17	0.00	0.00	QC10	
160	QC	1 pcs	10/30/17	0.00	0.00	QC5	
170	HandFinish	1 pcs	10/30/17	0.00	1.32	HandFinish2	
180	Powdercoat	1 pcs	10/30/17	0.00	0.34	Powdercoat1	
190	QC	1 pcs	10/30/17	0.00	0.00	QC3	
200	HandFinish	1 pcs	10/31/17	0.00	1.32	HandFinish3	
210	QC	1 pcs	10/31/17	0.00	0.00	QC5	
220	Packaging	1 pcs	10/31/17	0.00	0.00	Packaging3	
230	QC21-FG	1 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG005

Descriptions: 110 - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3-scribe each in aft end of tube

120 - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

140 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr 6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

170 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution. ..

180 - START TIME: 7:00 OUT: 3:20 FINISH 4:30 M 138014.

200 - 1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates Sikaflex expire date: 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

210 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2580-1 165740 x6163	0	0	0	0
140-Skidtubes	D2576-3 151399	1	0	0	0
	D4202-1 153348	20	0	0	0
200-HandFinish	ALS4 ALS7-1032-1305007279	50	0	0	0
	AN3-5A 5003184	2	0	0	0
	AN3C4A 5000533	50	0	0	0
	D2594-1 5011147	16	0	0	0
	D2594-3 F159710	16	0	0	0
	D2855 F151613	1	0	0	0
	D3564-11 F163892	1	0	0	0
	D3564-13 F159800	1	0	0	0
	D3564-5 F159445-1	1	0	0	0
	D3564-9 F163907	1	0	0	0
	D3566-1	2	0	0	0
	D3566-12	1	0	0	0
	D3566-5	1	0	0	0
	NAS1149C0332R 5001036	50	0	0	0
	NAS1149D0332J 5003036	2	0	0	0

Part Specifications
Specifications could not be found.

Plex 10/2/17 12:38 PM Dart.lajeunesse.marie

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Page 1

Item ID: D205-634-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH
Start Date: 9/1/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/11/2017 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: Uy ^{DAS} 21 ₉₋₈₉ Date: AUG 24 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580-041	H

100 Document Control 0.00
100 DOCUMENT CONTROL
DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

110 BENDING MACHINE - SKIDTUBES 0.10
110
CNC Bend 1 Memo 0.40
CNC Delta 100 Bender 1-Bend as per program D2580.C on CNC Bender and Folio 16
2-Cut tubes as per Dwg. D2580
3- scribe batch# in aft end of tube

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Quality Control

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Page 3

Item ID: D205-634-041**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Replacement Skidtube with Standard Wearplates Fits LH or RH**Start Date:** 9/1/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 9/11/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00

140

Skidtubes

Memo

1.53

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R Aluminum Rod _____

2-Grind welds on step as per Dwg D2580

3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start
expantion and finish with 1/2 x 18G to achieve dwg dimation.4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd
saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit
web.Deburr

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

150

QC10- Inspect visual per QSI004- ground welds 0.00

150

QC

Memo

0.00

Quality Control

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Item ID: D205-634-041**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Replacement Skidtube with Standard Wearplates Fits LH or RH**Start Date:** 9/1/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 9/11/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

160

QC

Memo

Quality Control

170	Pressure Wash per QSI005 4.3	0.00							
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170

HandFinish

Memo

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

180

Powdercoat

Memo

Powder Coating

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

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NS1

Stop ***NS2***

Stop ***NS2***

1

1

Customer:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.01

Quality Control

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Item ID: D205-634-041 **Accept** ***N900040100*** **Setup** **Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH
Start Date: 9/1/2017 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 9/11/2017 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Wing Walk as per dwg QSI005 4.4 Batch _____	0.00							
200									
HandFinish	Memo	1.56							
Hand Finishing	1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 _____ Sikaflex expire date: _____ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 _____ Sikaflex expire date: _____ 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: _____								

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Item ID: D205-634-041**Accept*****N900040100*****Setup****Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Replacement Skidtube with Standard Wearplates Fits LH or RH**Start Date:** 9/1/2017**Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 9/11/2017**Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run****Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

210

QC5- Inspect part completeness to step on W/O

0.00

210

QC

Memo

0.02

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Identify as per dwg & Stock Location: _____

0.00

220

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041
Location: _____
PPP Rev: _____

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.10

Quality Control

Picklist Print

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/1/2017

Required Date: 9/11/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS
PER ECN11-684 VERF:EC IPP Rev.S 17.07.06 As per ECN17-569
DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1		Manufactured	No			140	Each	262.0000	20	20			

D4202-1

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	262	
151107	21	
153348	76	
157276	19	
160406	146	

D2580-1

Manufactured No

110

Each

7.0000

1

1

D2580-1

205 Bent Tube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	7	
158578	1	
158778	1	
161226	1	
163522	4	

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Work Order ID: 165469

165469

Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/1/2017

Required Date: 9/11/2017

Start Qty: 1.00

Required Qty: 1.00

D2576-3 Manufactured No 140 Each 83.0000 1 1

D2576-3

Step (Machining Detail)

Location

Loc Qty

Loc Code

LG001

83

151399

33

156023

50

D2855 Manufactured No 200 Each 105.0000 1 1

D2855

Cap

Location

Loc Qty

Loc Code

FP001

105

147805

40

151613

65

AN3-5A Purchased No 200 Each 386.0000 2 2

AN3-5A

Bolt

Location

Loc Qty

Loc Code

GA

125

m137963

125

ST350

261

m136986

111

m137963

150

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Shop Packet Print

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/1/2017

Required Date: 9/11/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

200

Each

1,763.000

2

2

NAS1149D0332.J

Washer

Location

Loc Qty

Loc Code

FP	135	
m137075	135	
GA	198	
m136643	198	
ST260a	1000	
m138238	1000	
ST264	430	
m137963	430	

ALS7-1032-130

AELS8-1032-130

Purchased

No

200

Each

1,965.000

50

50

ALS7-1032-130

Rivnut

Location

Loc Qty

Loc Code

FG	100	
M128649	50	
M136048	50	
FP001	1855	
M128649	155	
M136579	1700	
ST556	10	
M136048	10	

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/1/2017

Required Date: 9/11/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

200

Each

1,790.000

50

50

AN3C4A

Bolt

Location

Loc Qty

Loc Code

FG	20
122814	20
FP001	647
M136450	23
M136740	8
M136986	20
M137075	43
M137164	2
M137361	2
M137587	250
M137820	23
M137963	276
OVER002	725
M137507	150
M138040	125
M138209	150
M138336	300
ST350	398
M135704	2
M138238	396

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/1/2017

Required Date: 9/11/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

200

Each

4,901.000

50

50

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

FP001

2955

m137851

1946

m137951

9

m138237

1000

GA

470

m133284

22

m136444

448

ST260a

1000

m138207

1000

ST266

476

m137381

476

D3564-11

Manufactured

No

200

Each

20.0000

1

1

D3564-11

Wearplate Aft

Location

Loc Qty

Loc Code

FG

4

77056

4

FP002

16

152217

1

161875

5

163892

10

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/1/2017

Required Date: 9/11/2017

Start Qty: 1.00

Required Qty: 1.00

D3564-13 Manufactured No 200 Each 34.0000 1 1

D3564-13

Wearpad Fwd

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
89044	2	
FP001	32	
147966	1	
156275	2	
158434	6	
159900	23	

D3564-9 Manufactured No 200 Each 25.0000 1 1

D3564-9

Wearplate Fwd

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	5	
76950	4	
88407	1	
FP002	20	
161940	8	
163907	12	

D3564-5 Manufactured No 200 Each 36.0000 1 1

D3564-5

Wearplate Center

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
34806	1	
89048	1	
FP002	34	
151722	1	
159873	5	
159945	28	

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Shop Packet Print

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Picklist Print

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 9/1/2017

Required Date: 9/11/2017

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

544.0000

16

16

D2594-3

O-Ring

Location

Loc Qty

Loc Code

FP001

544

153944

93

159710

451

D2594-1

Manufactured No

200

Each

295.0000

16

16

D2594-1

Plug

Location

Loc Qty

Loc Code

FP001

295

119830

65

134804

17

151587

3

159310

25

161779

150

42807

27

88922

8

ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2855	AFT CAP
28	1	1			D3564-5	WEARSHOE
29	1	1			D3564-9	WEARSHOE
30	1	1			D3564-11	WEARSHOE
31	1	1			D3564-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5061-1	FWD WEARPLATE
36				1	D5061-3	AFT WEARPLATE
50	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN860C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN860JD10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL 20.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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WITHOUT NOTICE
WORK ORDER
NO. 165469

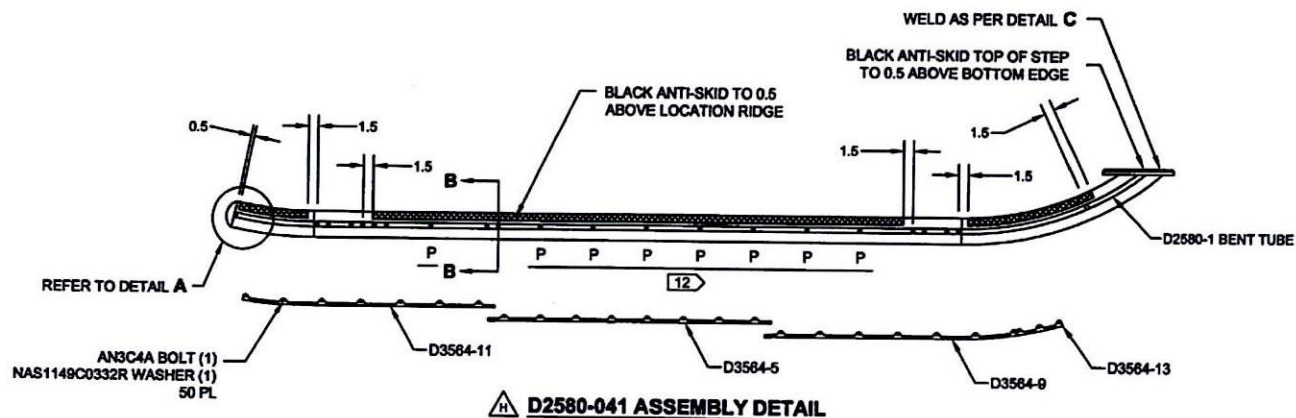
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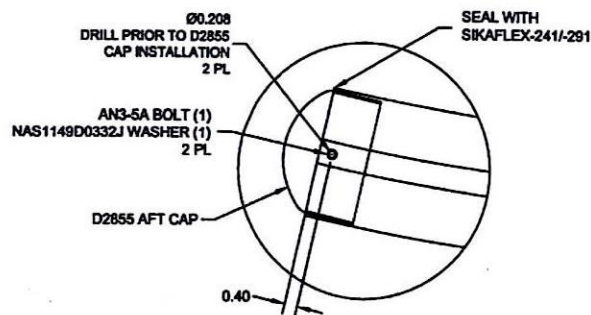
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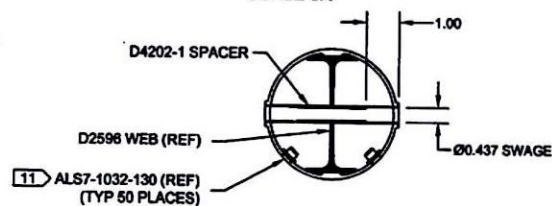
H	SHEET: PL DELETE D3566-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9696	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/9097	CP	98.06.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	DS	DRAWING NO.	REV. H
MFG. APPR.	DS	D2580	SHEET 1 OF 9
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DE APPR.	DS	205 SKIDTUBE ASSEMBLY	NTS
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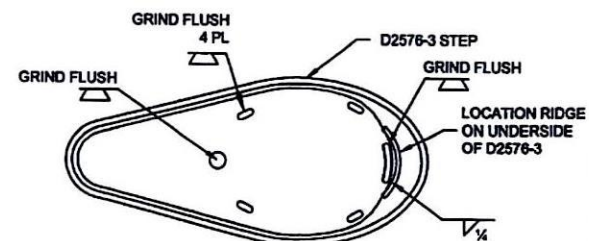


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

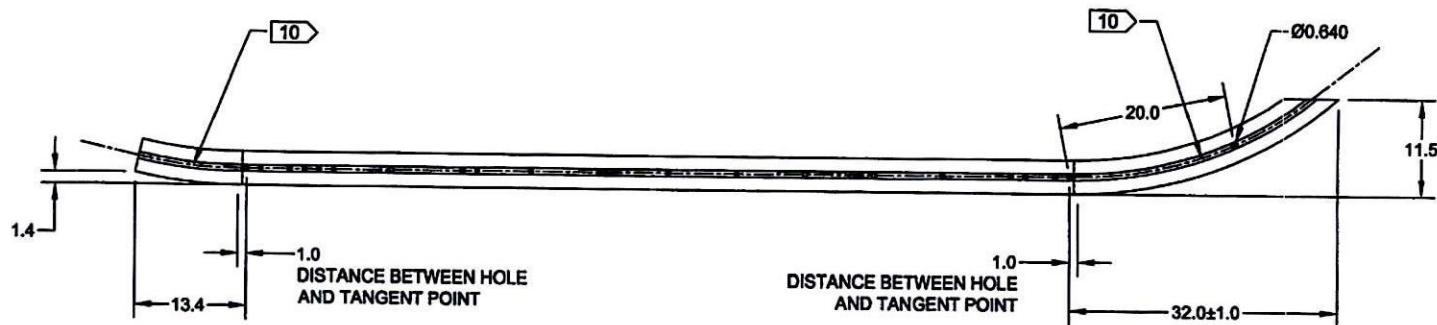
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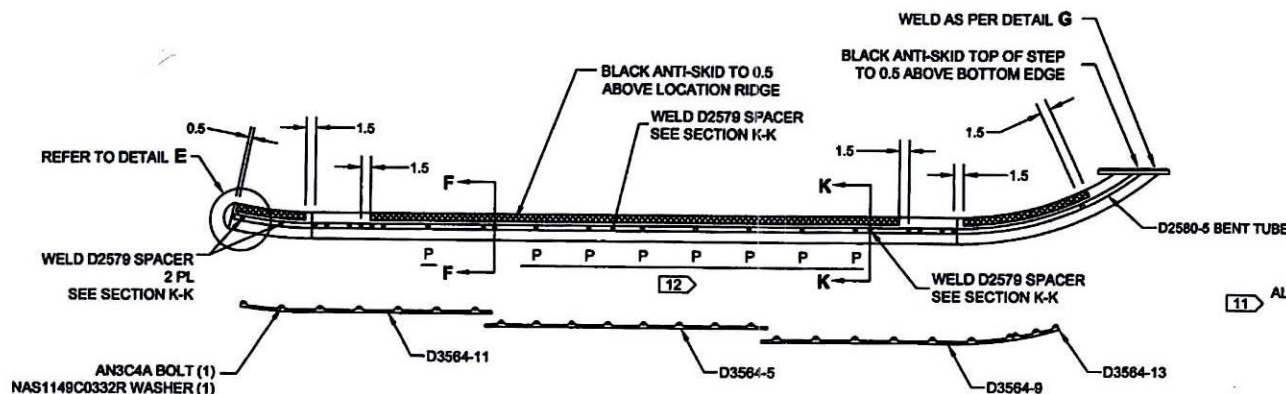
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

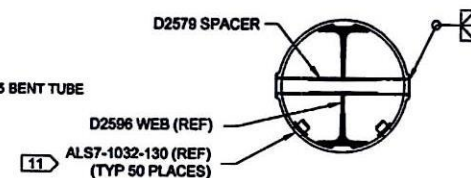
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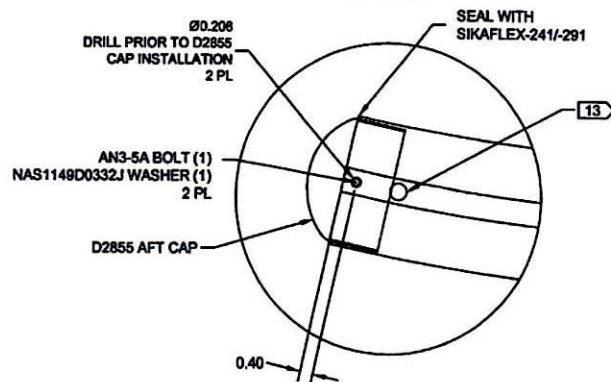
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
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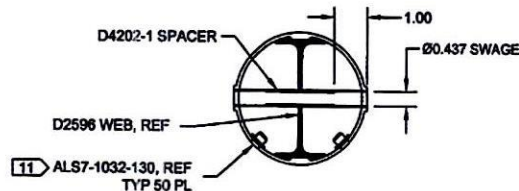


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

**DETAIL E
SCALE 5X**

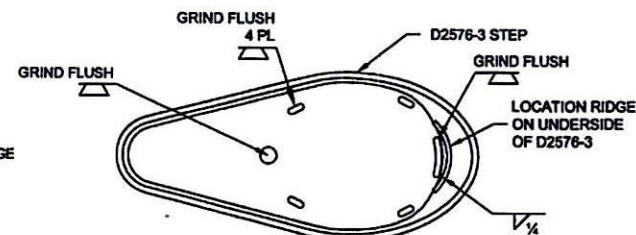


**SECTION F-F
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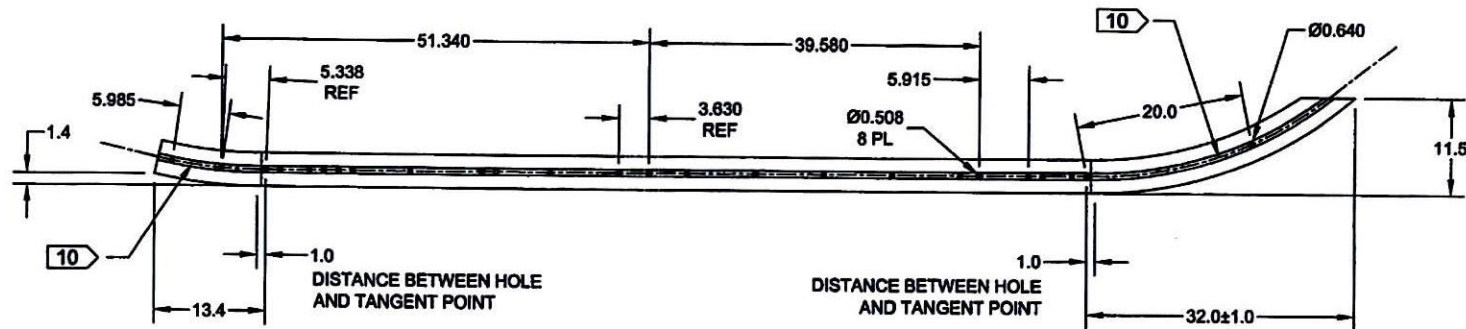
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

**DETAIL G
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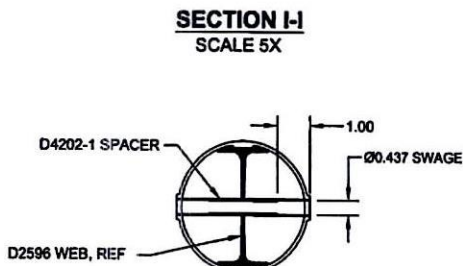
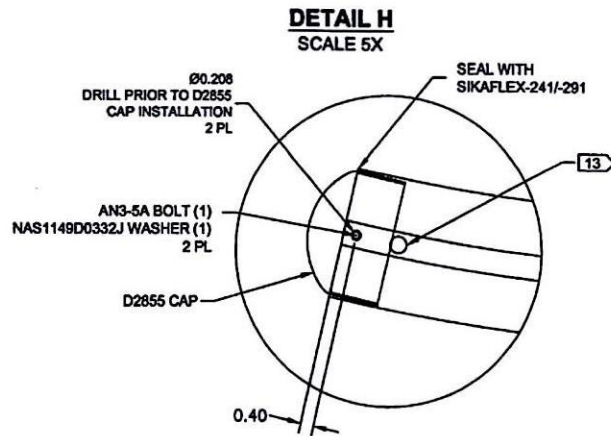
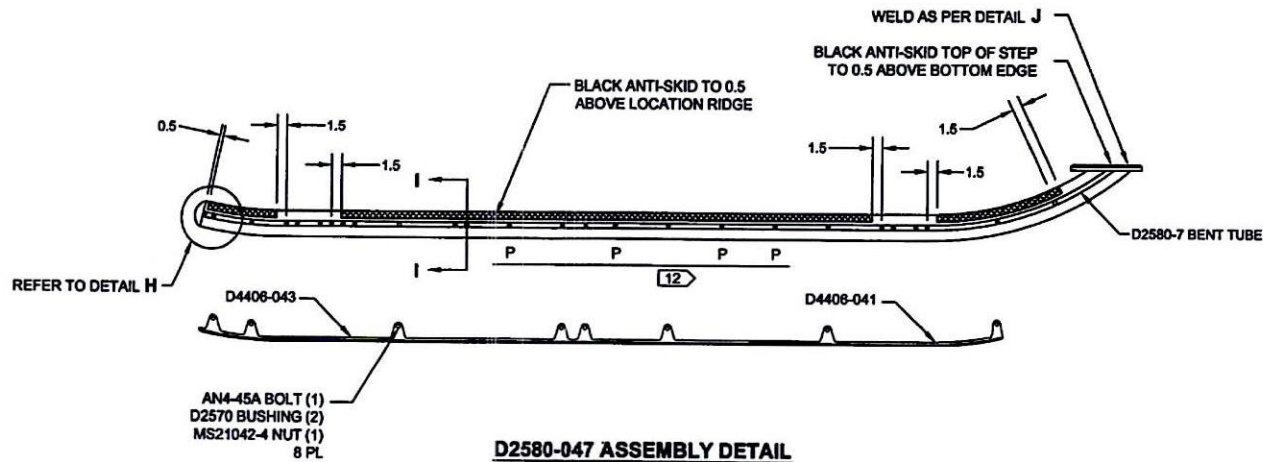
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D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

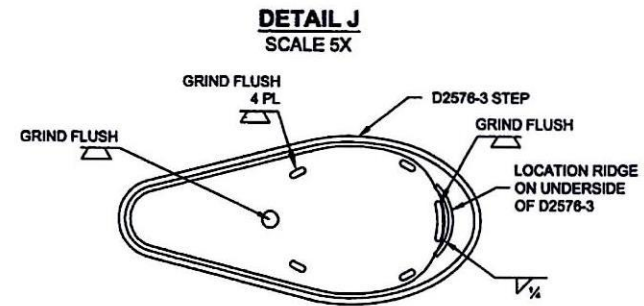
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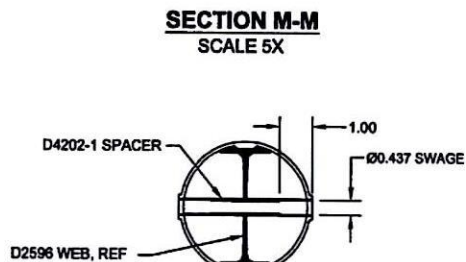
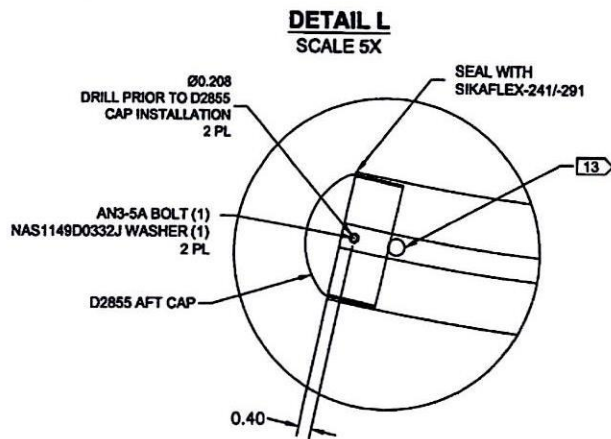
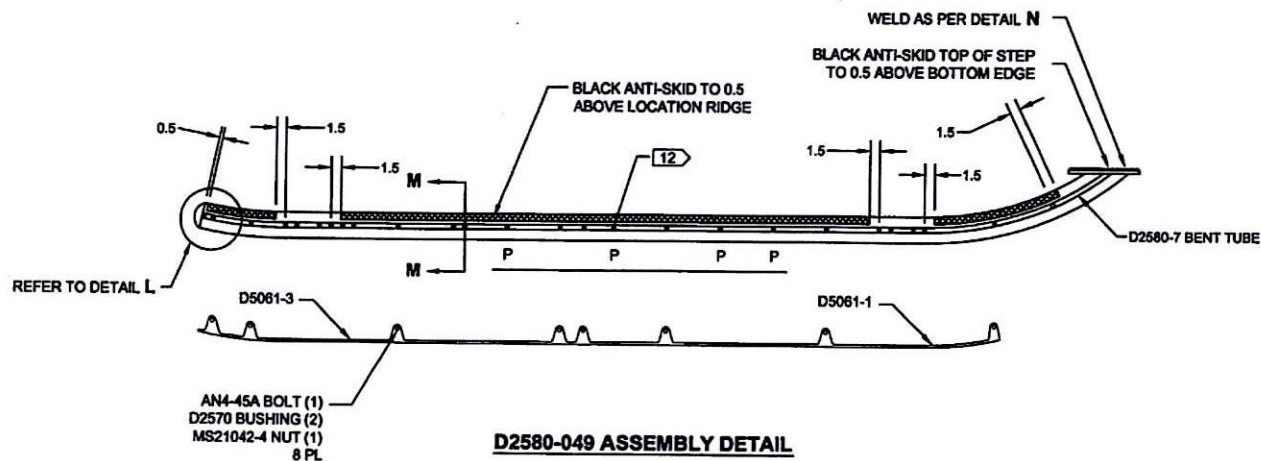
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

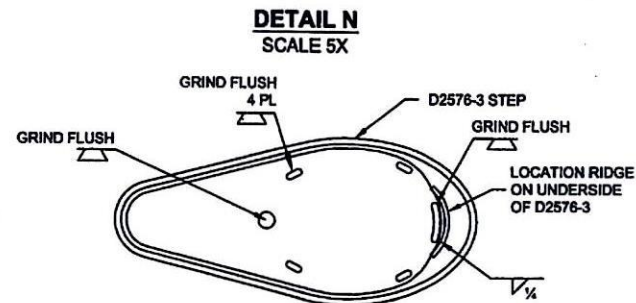


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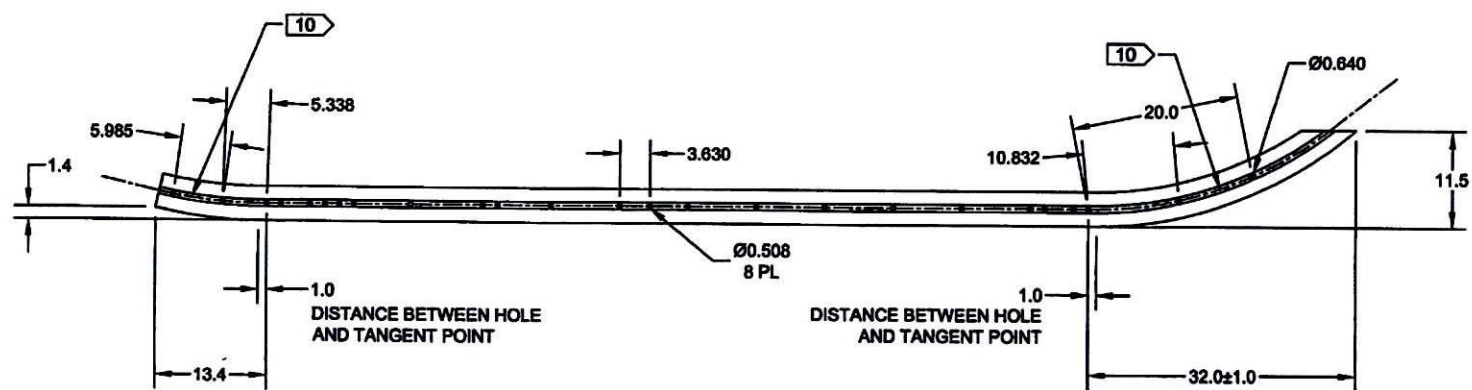
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PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
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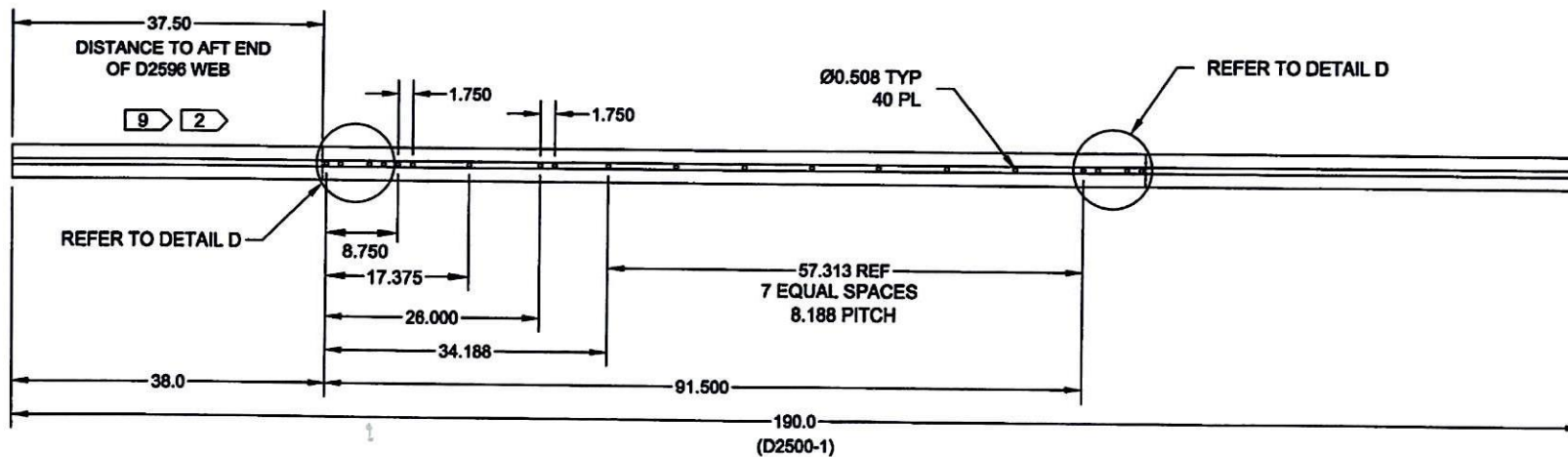


D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

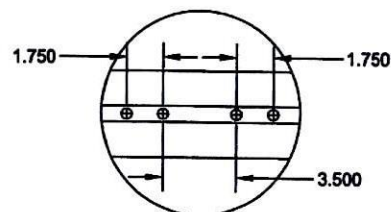
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APPROVED	<i>MB</i>	TITLE	SCALE
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D2580-101 TUBE



DETAIL D
SCALE 5X

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